



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT400325
Job Sheet 170435



Part No: RBT400325

Job Qty: 6 ea

Part Name: Socket Tail Boom Nut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT400325 Rev B IPP Rev A 17.12.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/30/18	0.00	0.00	Start Up Machining-2		J.L.-V.
110	Lathe Conv	6 pcs		1/30/18	0.00	1.50	Lathe Conv-1		J.C.-V.
120	QC	6 pcs		1/30/18	0.00	0.00	QC2 Machining-4		J.C.-V. 18-02-08
130	QC	6 pcs		1/30/18	0.00	0.00	QC8 Machining-4		IMP 18/02/18
131	HandFinish	6 pcs		1/31/18	0.00	0.60	HandFinish7		BEB 18/02-14.
132	Outsource	6 pcs		1/31/18	0.00	0.00	Outsource12		AT 08/03/05
133	Packaging	6 pcs		1/31/18	0.00	0.00	Packaging2		AD 08/03/05
134	QC	6 pcs		1/31/18	0.00	0.00	QC6		38
140	Packaging	6 pcs		1/31/18	0.00	0.00	Packaging3-1		9-88
150	QC21-SA	6 Ea		1/31/18	0.00	0.00	QC21		DAS

Part Op 110 - 1-Machine as per DWG. DWG REV: _____ Remove all factory markings 2-Debur
Descriptions: 130 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

131 - Bead blast, remove remaining chrome

132 - Issue P/O to Groupe Altech; PO 081039 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

140 - Bag and tag (T/N and revision number)

21 MAR 06 2018

208 FEB 15 2019

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	FM14	6	0	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S040669

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Socket Tail Boom Nut

PART NO: RBT400325

Original Serial #: S040669

Revision:

Operation: Start up Operation 02/08/18

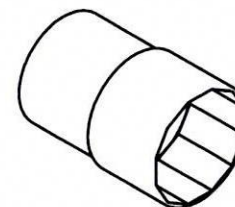
Change No:

Job No: 170435

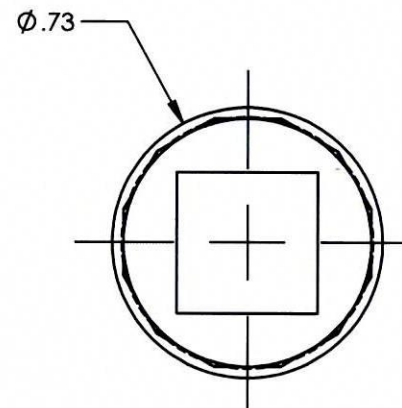
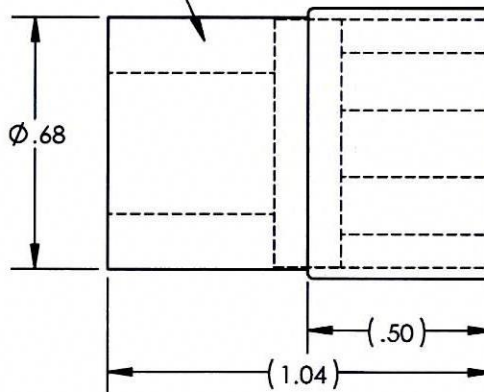
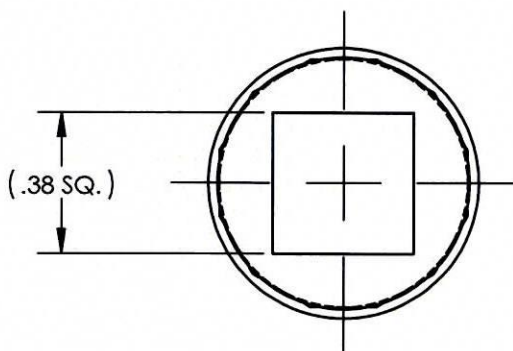
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D BUYOUT SOCKET FROM SNAP-ON #FM17.	2/17/2012	RJC	RW
B	DIM WAS .59 IS (.500) DIM WAS 1.04 IS (1.04).	1/3/2013	BIM	GE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170435 *hcs*
18-01-16



ENGRAVE T/N, S/N,
"MADE IN USA"



NOTE:
1. ORIGINAL BELL #407-230-001-101.
2. REMOVE ALL FACTORY MARKINGS.

RED BARN MACHINE	
TITLE SOCKET TAIL BOOM NUT	
DWG NO. RBT400325	REV B
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1	DRAWN BY: CLOUGH APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL 407
SCALE 2:1	DATE 10/12/2011 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	SOCKET TAIL BOOM NUT		3/8 DR. 14MM, 12PT. SNAP-ON #FM14 (NEEDS MODIFIED)	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____						



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039039

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039039
PO Date: 2/14/18
Due Date: 2/27/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:
Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170480	646.3911	Shim Issue P/O: _____ Cad Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	2/27/18	32 pcs	0 pcs	32 pcs	\$4.25/pcs	\$136.00
2	170958	RBE350A93-3312-03-5	Seat -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	2/27/18	6 pcs	0 pcs	6 pcs	\$1.35/pcs	\$8.10
3	170959	RBE350A93-3312-03-7	Washer -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	2/27/18	6 pcs	0 pcs	6 pcs	\$1.35/pcs	\$8.10
4	170952	RBE350A94-2704-00-1	Plate -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	2/27/18	20 pcs	0 pcs	20 pcs	\$3.89/pcs	\$77.80
5	170957	RBE350A93-3312-03-3	Remover / Installer -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	2/27/18	6 pcs	0 pcs	6 pcs	\$1.35/pcs	\$8.10
✓ 6X AT 19.10.23/05										

OK
AT 19/03/18



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PURCHASE ORDER

PO039039

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	170435	RBT400325	Socket Tail Boom Nut -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	2/27/18	6 pcs ✓	0 pcs 6x	6 pcs AT	\$1.35/pcs 1/3/05	\$8.10
7	170781	RBE8814164002	Special Wrench -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	2/27/18	1 pcs	0 pcs	1 pcs	\$1.95/pcs	\$1.95
8	171171	RBE350A93- 3307-00-01	Retractor -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	2/27/18	6 pcs	0 pcs	6 pcs	\$2.55/pcs	\$15.30
Grand Total:										\$263.45

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Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit
www.dartaerospace.com for further explanation.

Plex 2/23/18 9:58 AM dart.baker.diane



Certificat de Conformité / Certificate of Compliance

(006931-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

006931 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Carrier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
27-Feb-2018		Aman Kaur		PO039039				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	646.3911 Rev.	646.3911 CAD PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM CH	32	32	0	0	0
2	RBE350A93-3312-03-5 Rev.	RBE350A93-3312-03-5 01 -OXIDE BLACK [OXIDE BLACK]	BLACK-OXIDE CH	6	6	0	0	0
3	RBE350A93-3312-03-7 Rev.	RBE350A93-3312-03-7 01 -OXIDE BLACK [OXIDE BLACK]	BLACK-OXIDE CH	6	6	0	0	0
4	RBE350A94-2704-00-1 Rev.	RBE350A94-2704-00-1 01 -OXIDE BLACK [OXIDE BLACK]	BLACK-OXIDE CH	20	20	0	0	0
5	RBE350A93-3312-03-3 Rev.	RBE350A93-3312-03-3 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	6	6	0	0	0
6	RBT400325 Rev.	RBT400325 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	6	6	0	0	0
7	RBE8814164002 Rev.	RBE8814164002 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	1	1	0	0	0
8	RBE350A93-3307-00-01 Rev.	RBE350A93-3307-00-01 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	6	6	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.